

AUG 21 2018

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada



Tel (613) 632-5200
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D412-705-023
Job Sheet 182233



Part No: D412-705-023 Job Qty: 2 ea

Part Name: Oil Cooler Support Removable Lower Panel



Part Weight: 0 lbs Status: Scheduled Priority: Medium

Job Created: 8/21/18 Job Tracking No:

Due Date: 9/7/18 Created By: Marie Lajeunesse

Type: Stock Description:

Note: DWG REV F SHEET 18 IPP A-05.02.07 New issue KJ/JLM IPP Rev:B ECN 1052 07-11-06 DD verified by: EC

Ship Via: *Chgoosi mail see attachment*
9-89 *MLW*

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	9/7/18	9/7/18	0.00	0.00	Start Up Stores/Pkg-1		
110	Packaging	2 pcs	9/7/18	9/7/18	0.00	0.00	Packaging1-4		
120	QC	2 pcs	9/7/18	9/7/18	0.00	0.00	QC4		
130	Packaging	2 pcs	9/7/18	9/7/18	0.00	0.00	Packaging3-2 <i>F6023</i>		
135	DC	2 pcs	9/7/18	9/7/18	0.00	0.00	DC		
140	QC21-FG	2 Ea	9/7/18	9/7/18	0.00	0.00	QC21		

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9-89 **AUG 30 2018**

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-3A	Bolt	60 Ea (30 ea)	90-Start up Operation	<i>S08462</i>
MS21051-L3K	Nut Plate	8 Ea (4 ea)	90-Start up Operation	<i>FM112865</i>
MS21069-L3K	Nut Plate	36 Ea (18 ea)	90-Start up Operation	<i>FM135442304K</i>
NAS1149D0363J	Washer	60 Ea (30 ea)	90-Start up Operation	<i>S06866</i>

S06866 22 x22

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-3A	60	472	0
	MS21051-L3K	8	182	0
	MS21069-L3K	36	64	0
	NAS1149D0363J	60	1,835	0

Part Specifications



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Container No: **\$106875**



Part: **D412-705-023**

Job No: **182233**

Serial No/Batch: **\$106875**

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH04-25 Issue 1 **FAA-CTC ST019941**

Plex 8/21/18 8:40 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Part Number	Description
X							D412-705-011	TWIN PAK E-Z ACCESS KIT
1	X						D412-705-013	INTAKE PLENUM ACCESS PANEL KIT
1		X					D412-705-015	DRIVESHAFT TUNNEL MODIFICATION KIT
1			X				D412-705-017	N1 GEARBOX ACCESS PANEL KIT
1				X			D412-705-019	C-BOX OIL COOLER LINE SUPPORT ACCESS KIT
1					X		D412-705-021	OIL PRESSURE TRANSMITTER ACCESS KIT
1						X	D412-705-023	OIL COOLER SUPPORT REMOVABLE LOWER PANEL KIT
	1						D3245-041	ACCESS PANEL ASSEMBLY, LH
	1						D3245-042	ACCESS PANEL ASSEMBLY, RH
	2						D3245-043	DOOR ASSEMBLY
	2						D3245-9	GASKET
	2						D3245-11	GASKET
	2						D3245-13	GASKET
			1				D3255-041	ACCESS PANEL ASSEMBLY, LH
			1				D3255-042	ACCESS PANEL ASSEMBLY, RH
		1					D3256-1	ACCESS PANEL
		1					D3256-3	GASKET
				1			D3259-041	ACCESS PANEL ASSEMBLY, LH
				1			D3259-042	ACCESS PANEL ASSEMBLY, RH
					1		D3307-041	ACCESS PANEL ASSEMBLY
						30	AN3-3A	BOLT
		22	30		6		AN3C3A	BOLT
		3					AN3C4A	BOLT
						30	AN960JD10	WASHER
16	44	36			12		MS20427M3-3	* RIVET
						4	MS21051-L3K	NUT PLATE
8	22	18			6		MS21060-L3K	NUT PLATE
						18	MS21069-L3K	NUT PLATE
		25	30		6		MS9321-09	WASHER

* Acceptable to substitute for MS20615M3-3 rivets. At installation, it is acceptable to use longer rivets if required.

REFERENCE ONLY

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Change Record

PAGE 1 OF 1

Part Number: D412-705-023

Description: OIL COOLER SUPPORT REMOVABLE LOWER PANEL

[illegible]

